












*Handwritten signature*

Date: Wednesday, 18/04/2007 8:20:39 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : COVER	
Job Number : 31658			
Estimate Number : 10287			
P.O. Number : <i>N/A</i>		Part Number : D32021	
This Issue : 18/04/2007 S.O. No. : <i>N/A</i>		Drawing Number : D3202 REV B1	
Prsht Rev. : NC		Project Number : N/A	
First Issue : <i>N/A</i> Type : PURCHASED PARTS		Drawing Revision : B1	
Previous Run : 31658		Material : <i>N/A</i>	
Written By : <i>[Signature]</i>		Due Date : 30/04/2007 Qty: 12 Um: Each	
Checked & Approved By : <i>[Signature]</i>			
Comment : Est Rev:B No Longuer Made In House 05-11-06 JLM Est Rev:C Now on Waterjet 07-04-18 JLM			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S032	5052-H32 .032 Sheet	
			
Comment: Qty.: 1.6286 sf(s)/Unit Total : 19.5426 sf(s) 5052-H32 .032 Sheet Batch: <i>M 100470</i> <i>M 07 05 25</i> (12)			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3202 Dwg Rev: <i>B1</i> <i>M 07 05 25</i> (12) Prog Rev: <i>B1</i> 2-Deburr if necessary <i>MF 07-05-29</i> (12)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 07 05 25</i> (12)			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>J 05-28</i> (12)			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>HS 07-05-29</i> (12)			

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 31658

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 10/60/



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/am

07/05/30 (12)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SP

7/5/30 SQ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 221

2/5/30 SP



(12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



1/5/30 SP



(12)

Comment: FINAL INSPECTION/W/O RELEASE

D32021/01

Job Completion



NOT 31

Date: Thursday, 4/12/2007 8:21:58 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 31658	
Estimate Number : 10287	
P.O. Number :	Part Number : D32021
This Issue : 4/12/2007 S.O. No. :	Drawing Number : D3202 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B1
Previous Run : 25557F	Material :
Written By :	Due Date : 4/30/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:B No Longer Made In House 05-11-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg

Possible supplier: Ind. Laser

Material release note is required.

*1.55190  
MS052H32.5 032*

*[Large handwritten signature]*

2.0

D32021F

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Cover

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 31658

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

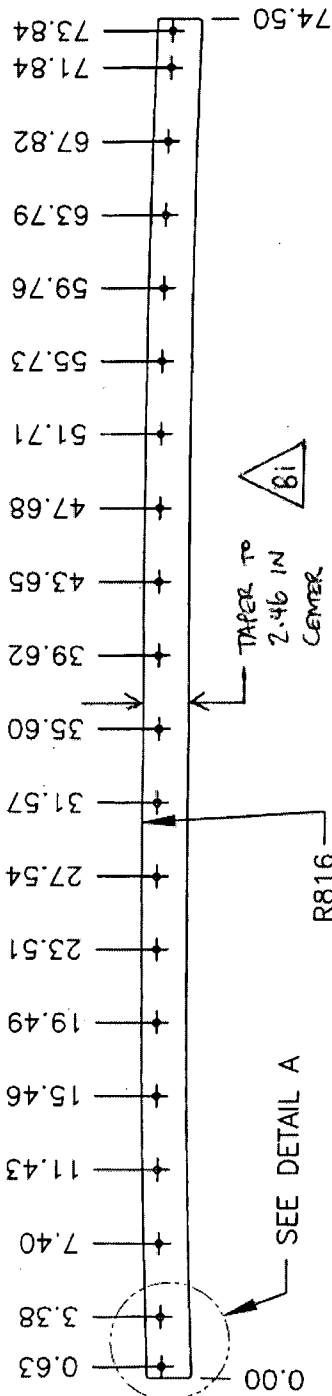
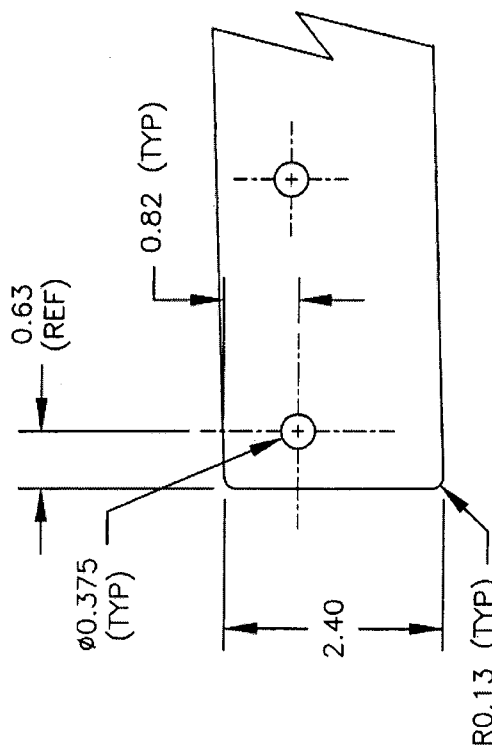
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3202	REV. B SHEET 1 OF 1
DATE 03.10.16		TITLE COVER	SCALE 1:10
A	01.01.01	NEW ISSUE	
B	03.10.16	REDESIGN; PART NOW CURVED	
BI	<i>[Signature]</i> 04.05.14	CLARIFY MID-SPAN DIMENSION	

**RELEASED**03.11.07 *[Signature]***DETAIL A  
SCALE 1:2**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **31658**

**D3202-1 COVER**

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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